

**IN THE CLAIMS:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

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- B2* 1. (Currently amended) Rotary drum for a tape recorder for recording and/or reproducing signals according to helical scan system, comprising:  
a rotary upper drum;  
a stationary lower drum for mounting said rotary upper drum; and,  
a drum base for mounting said stationary lower drum to form an assembly having a tilt angle with regard to a tape deck chassis plane, wherein; and  
a weld that fixes said drum base and to said lower drum, ~~are welded together~~ said weld disposed at an abutting area of the drum base and the lower drum.
2. (Previously amended) The rotary drum according to claim 1, wherein said drum base and said lower drum are welded with a laser beam.
3. (Previously amended) The rotary drum according to claim 1, wherein said drum base and said lower drum are through-welded by laser beam directed towards a lower side of said drum base.
4. (Previously amended) The rotary drum according to claim 1, wherein said drum base is provided with regions of reduced thickness for laser beam welding.
5. (Previously amended) The rotary drum according to claim 1, wherein said abutting area of said drum base and said lower drum are welded by laser beam applied radially at predetermined circumferential locations.
6. (Canceled)
7. (Previously presented) The rotary drum according to claim 3, wherein said laser beam is applied orthogonally to said lower side of said drum base .
8. (Previously presented) The rotary drum according to claim 3, wherein said laser beam is applied orthogonally to said abutting area of said drum base and said lower drum from said lower side of said drum base .

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9. (New) A method for manufacturing a rotary drum for a tape recorder that records and/or reproduces signals according to helical scan system, comprising:  
    providing a rotary upper drum;  
    providing a stationary lower drum for mounting said rotary upper drum;  
    providing a drum base for mounting said stationary lower drum to form an assembly having a tilt angle with regard to a tape deck chassis plane; and  
    welding said drum base to said lower drum at an abutting area of the drum base and the lower drum.
10. (New) The method according to claim 9, wherein said welding step comprises welding said drum base to said lower drum with a laser beam.
11. (New) The method according to claim 10, wherein said welding step comprises radially directing said laser beam at said abutting area at predetermined circumferential locations.
12. (New) The method according to claim 10, wherein said welding step comprises directing said laser beam at said abutting area from a lower side of said drum base to through-weld said drum base to said lower drum.
13. (New) The method according to claim 12, wherein said welding step comprises applying said laser beam orthogonally to said lower side of said drum base.